

Grey

Dart Aerospace Ltd.

Date: Monday, 09/03/2009 1:46:22 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ADAPTER
Job Number : 46351	
Estimate Number : 12753	
P.O. Number :	Part Number : D35738
This Issue : 09/03/2009 S.O. No. :	Drawing Number : D3573 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 32541	Material :
Written By :	Due Date : 26/03/2009 Qty: 8 Um: Each
Checked & Approved By : JLD 09.03.09	
Comment : Est Rev:A New Issue 07-01-29 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X02500	6061-T6 Bar .500 x 2.50
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Comment: Qty.: 0.3066 f(s)/Unit Total : 2.4528 f(s)
6061-T6 Bar .50" x 2.5"
Batch: M104366

JL 09/03/22

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blank 3.500" long

JL 09/03/22

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA679 and Dwg D3573

JL 09/03/23

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/03/23

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

88 09/03/23 (8)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

JLD 09-03-23 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:46:22 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 46351

Part Number: D35738

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109648

START TIME:

11:15

OVEN TEMPERATURE:

320°

FINISH TIME:

11:45

BR 09-04-2

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-02

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

STAY

JS A

09-04-03

(X8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/06

Job Completion



MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46351
Description: Adapter		Part Number: D3573-8
Inspection Dwg: D3573	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

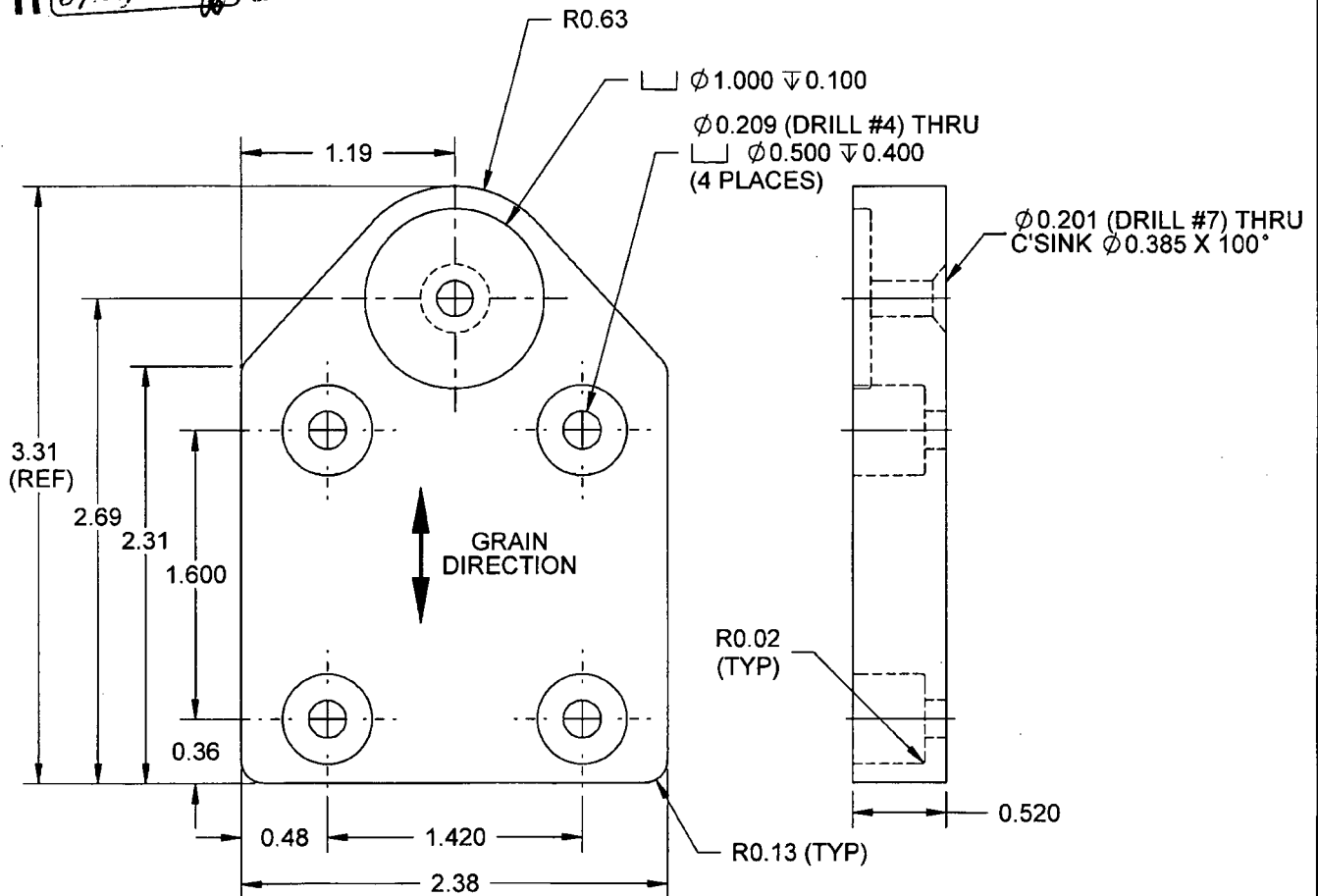
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.32	+/-0.030	3.317	✓			
2.75	+/-0.030	2.750	✓			
0.36	+/-0.030	.360	✓			
1.600	+/-0.010	1.600	✓			
0.48	+/-0.030	.480	✓			
2.38	+/-0.030	2.379	✓			
1.420	+/-0.010	1.420	✓			
1.813	+/-0.010	1.813	✓			
Ø0.209	+0.005/-0.001	.211	✓			
Ø0.201	+0.005/-0.001	.203	✓			
Ø0.90 x 0.100	+/-0.010	.897 x .101	✓			
Ø0.500 x 0.310	+/-0.010	.493 x .300	✓			
0.390	+/-0.010	.390	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.386 x 100°	✓			
R0.63	+/-0.030	r.630	✓			
R0.13	+/-0.030	r.130	✓			
R0.02	+/-0.030	r.015	✓			

Measured by: J.L.	Audited by: SP	Prototype Approval:	N/A
Date: 09/03/23	Date: 09/03/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	BE

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07.03.22**D3573-1 ADAPTER**

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **46351**

NOTES:

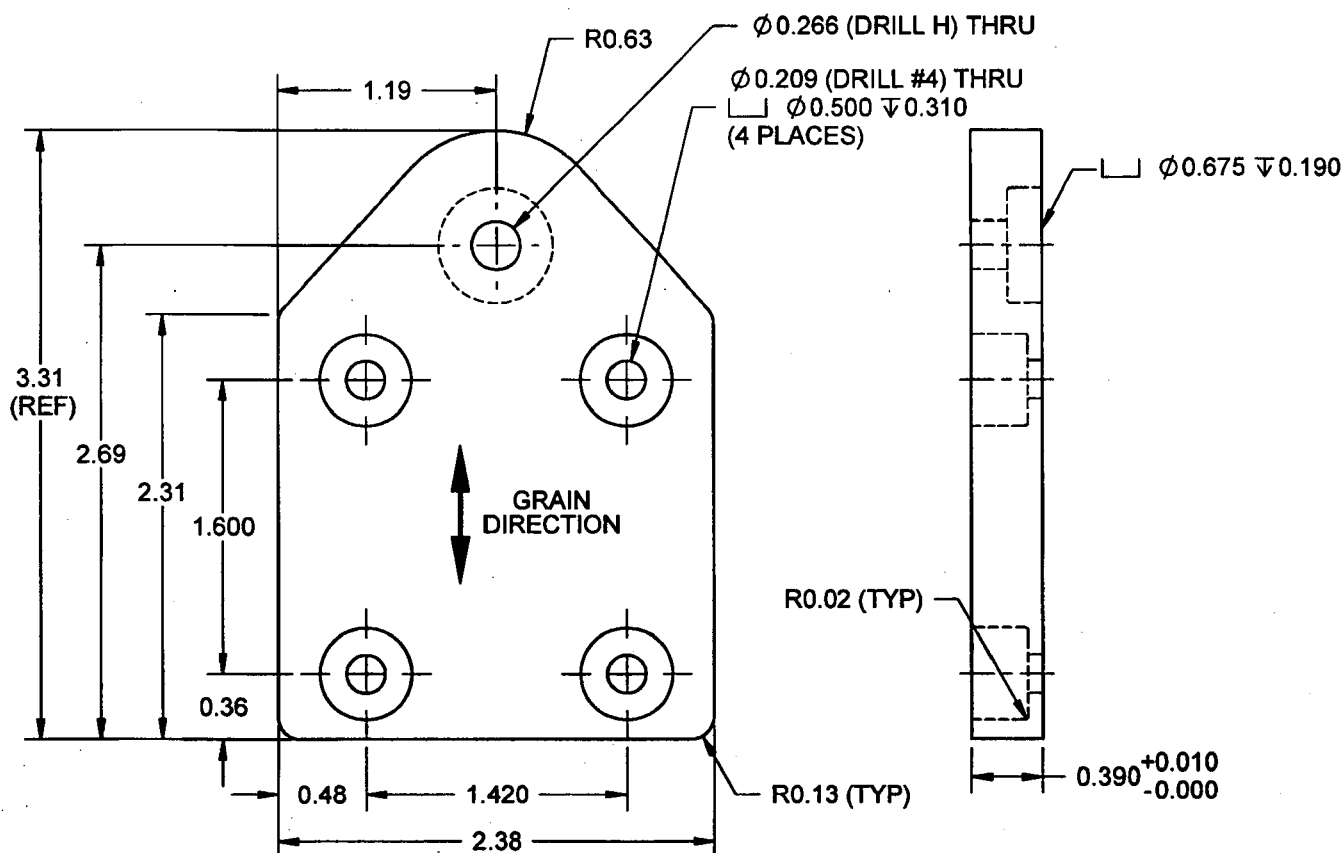
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

RELEASED
07.04.02**D3573-3 ADAPTER**

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NO. 46351

NOTES:

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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

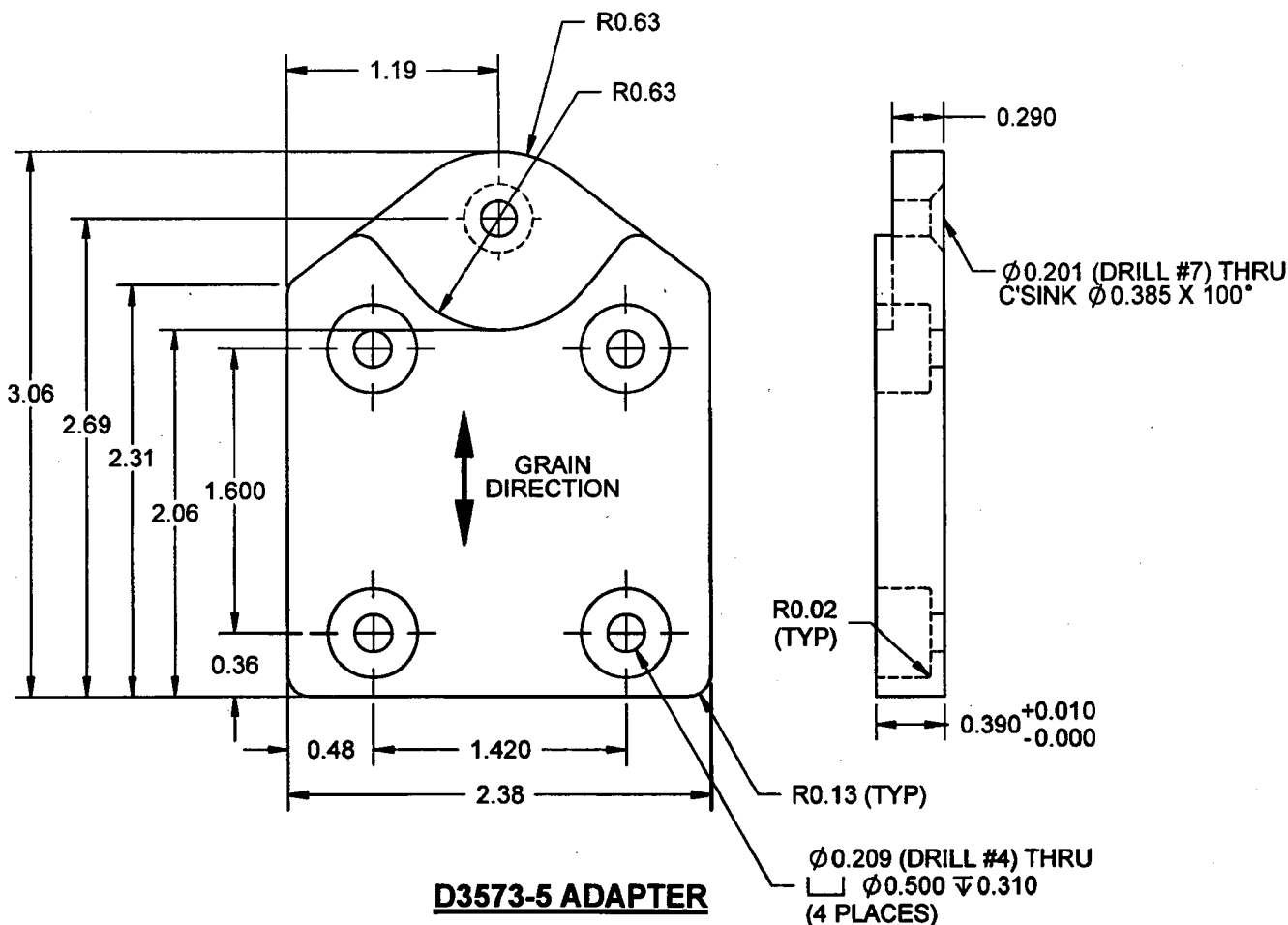
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DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02



D3573-5 ADAPTER

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WORK ORDER
NO 46351

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(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

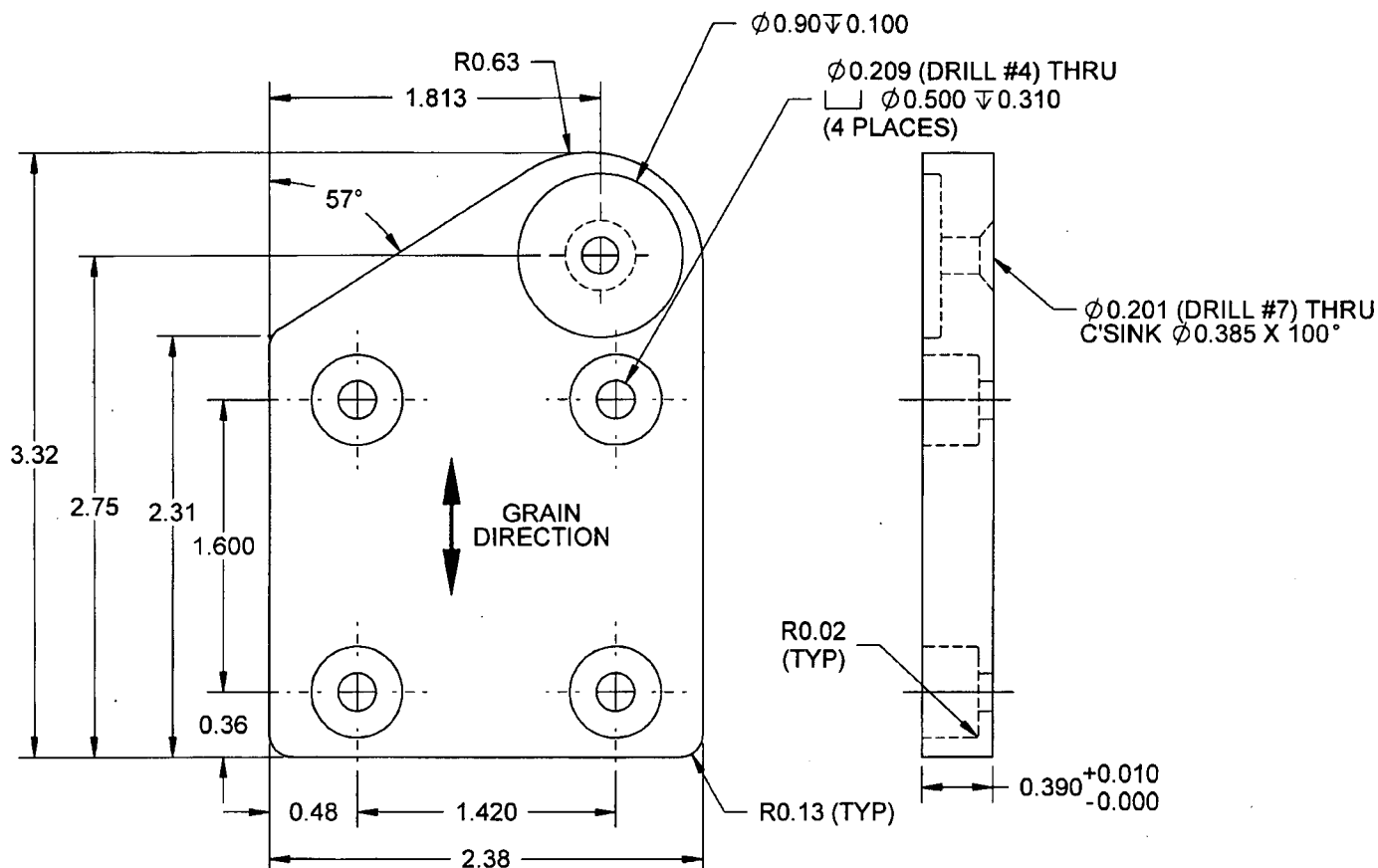
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DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

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NO 410351

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- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
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